

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-567 REV. C

REF. CANADIAN STC: SH92-18

REF. FAA STC: SH989NE/SH990NE

To make the Dart D350-567-111 Vertical Reference Window Installation Kit at CHG 002 and D350-567-115 Interior Floor Window Kit at CHG 001 compatible with later AS350/355 Aircraft, it may be necessary to notch and reinforce the D3294-1 Bracket per Figure 1. This change is required to ensure that the D3294-1 Bracket will not interfere with the pilot's right hand aft seatbelt anchor structure (notch per View A of Figure 2) and/or the collective tube (notch per View B of Figure 2).

Procedure

- 1) As required, notch D3294-1 Bracket per View A and/or View B of Figure 2. Views A and B of Figure 2 indicate the maximum size of the notch. If machining slot per View A, maintain a minimum edge distance of 0.125" from the edge of the holes.
- 2) Touch up affected areas on D3294-1 Bracket with chemical film (Alodine 1200/1201) per MIL-C-5541 before painting. Apply one coat of MIL-P-85582/MIL-P-23377 primer and 2-3 coats of MIL-C-83285 polyurethane paint to match original finish.
- 3) Prepare doubler per Figure 3. Figure 3 represents the minimum size of the doubler.
- 4) Prepare the doubler for paint with chemical film (Alodine 1200/1201) per MIL-C-5541. Apply one coat of MIL-P-85582/MIL-P-23377 primer and 2-3 coats of MIL-C-83285 polyurethane paint to match finish and color on D3294-1 Bracket.
- 5) Install Doubler on D3294-1 Bracket using MS20470AD4 Rivets as shown in Figure 1.
- 6) Install the modified D3294-1 Bracket in accordance with Installation Instructions D350-567.

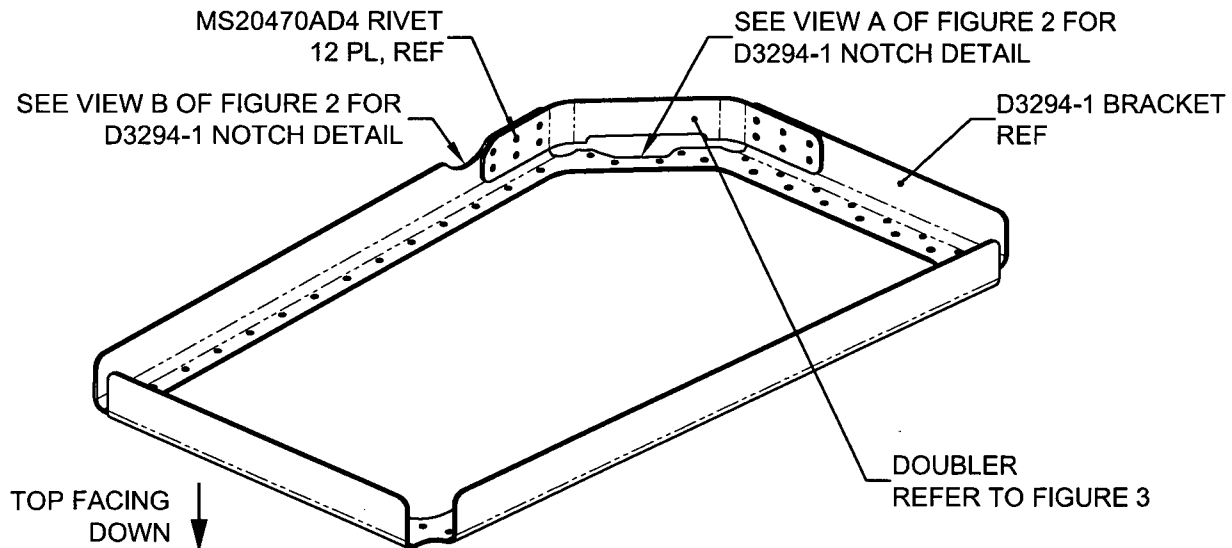


FIGURE 1: INSTALLATION OF DOUBLER

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
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DATE:	08.04.14
CERT. NO.:	SH92-18
ISSUE NO.:	5

B	ADD NOTCH PER VIEW B, NOTES AND CHAMFER ON DOUBLER. REF ECN#1175	MB	08.04.14
A	NEW ISSUE	MB	07.10.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>	DRAWING NO. REV. B DSI 9392 SHEET 1 OF 3	
CHECKED	<i>[Signature]</i>	TITLE SCALE BRACKET MODIFICATION NTS	
MFG. APPR.	<i>[Signature]</i>	DATE 08.04.14	
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NOTCH TO ELIMINATE
INTERFERENCE WITH
COLLECTIVE TUBE

VIEW A

REMOVE THIS TAB TO ELIMINATE
INTERFERENCE WITH PILOT SEAT
ANCHOR STRUCTURE

VIEW B

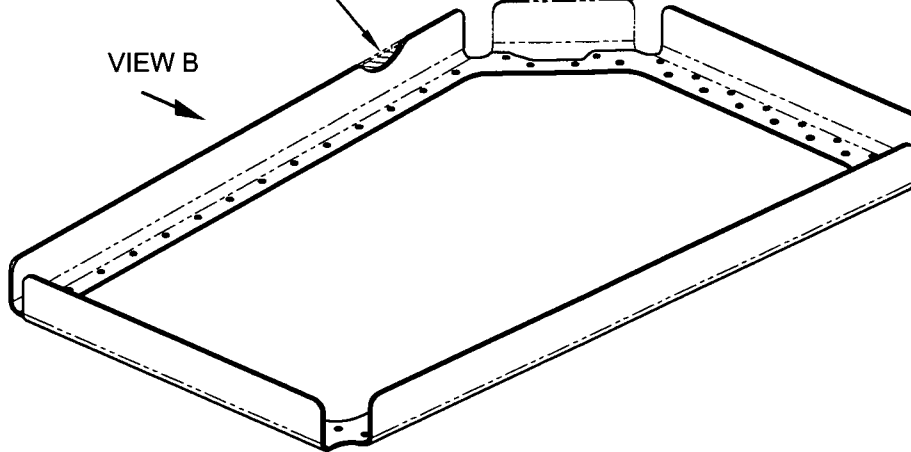


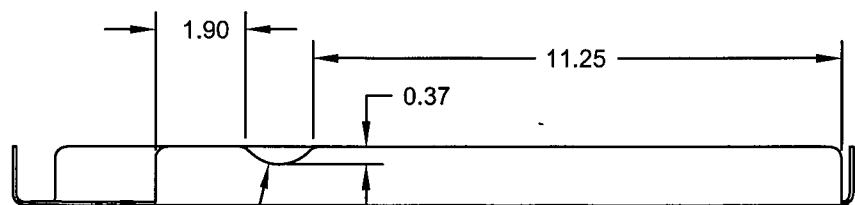
FIGURE 2: DETAIL OF D3294-1 NOTCHES

EXISTING
RIVET HOLES
REF

1.77
REF

0.125 MINIMUM
EDGE DISTANCE
TYP

VIEW A



R0.88

VIEW B

FIGURE 2 NOTES

- 1) UNITS: INCHES UNLESS OTHERWISE NOTED
- 2) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

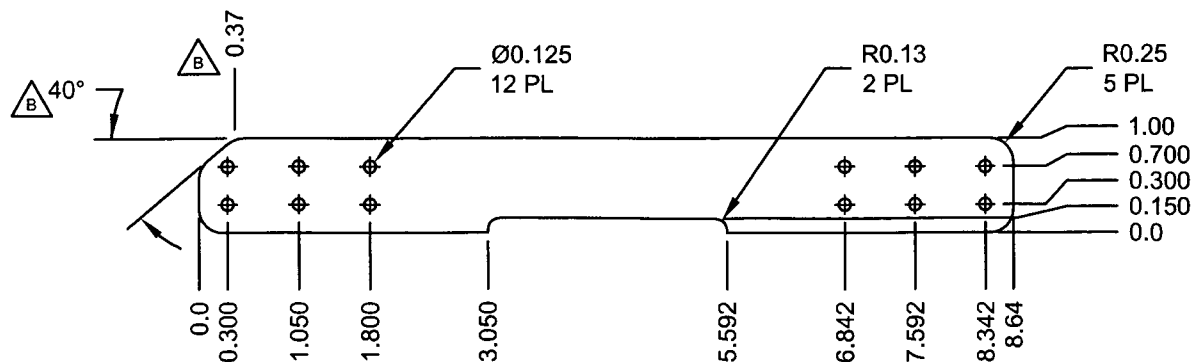
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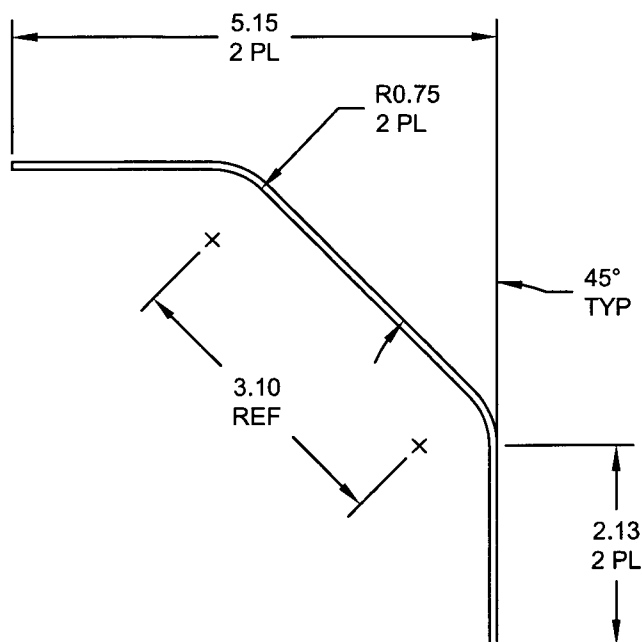
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DOUBLER FLAT PATTERN

DOUBLER NOTES:

- 1) MATERIAL: ALUMINUM 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX



DOUBLER BENDING DETAIL

FIGURE 3: DOUBLER DETAIL

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